

Date: Wednesday, 7/12/2006 3:24:24 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	1/4 TURN FASTNER RAIL (BLACK)
Job Number :	27878		
Estimate Number :	10096		
P.O. Number :	NIA	Part Number :	D103858B
This Issue :	7/12/2006	S.O. No. :	NIA
Prsht Rev. :	NC	Drawing Number :	D1038
First Issue :	NIA	Project Number :	N/A
Previous Run :	26486	Drawing Revision :	B
	Type :	Material :	NIA
	MACHINED PARTS	Due Date :	7/30/2006
Written By :	Qty:		80 Um: Each
Checked & Approved By :	06.07.12 W		
Comment :	Est: 03.05.02 Reformat; Added label KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Create white labels and bag them

2.0	D2023	Extrusion, Fastener Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 80.0000 Each(s)
 Extrusion, Fastener Rail
 Batch: 21907

J.F. 06/07/17

(80)

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

J.F. 06/07/17

(80)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio and Dwg D1038-58

J.F. 06/07/17

(80)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/07/17

(80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/12/2006 3:24:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 27878

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/18 x 80

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 06:07:20

80

(P2)

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 1740
Black Anodize as per Dwg D1038

U DB-0721

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

U 8/01 (80)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

ml 06/08/02

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

49

1- Stake 050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: M9050

2-Grind wire flush and deburr

3-Clean

ml 06/08/09

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/08/09

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-20	7.1	Add QCS to estimate. perm. Change. QCS done by 06-07-20		06-08-16			060720

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 27878

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- ml*
06/08/11
- 1-Pack each fastener rail into a cardboard tube
 - 2 - Piece of foam on each tube
 - ~~2-Taper ends to close cardboard tubes~~
 - 3- install red bottom on tube, fix them with ~~staple~~ tape
 - 4- ~~X~~ Apply white labels to cardboard tubes

ml
5 - ~~X~~ Identify and Stock

Location: 47

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD *06/08/11* *(80)*

Job Completion



C206/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

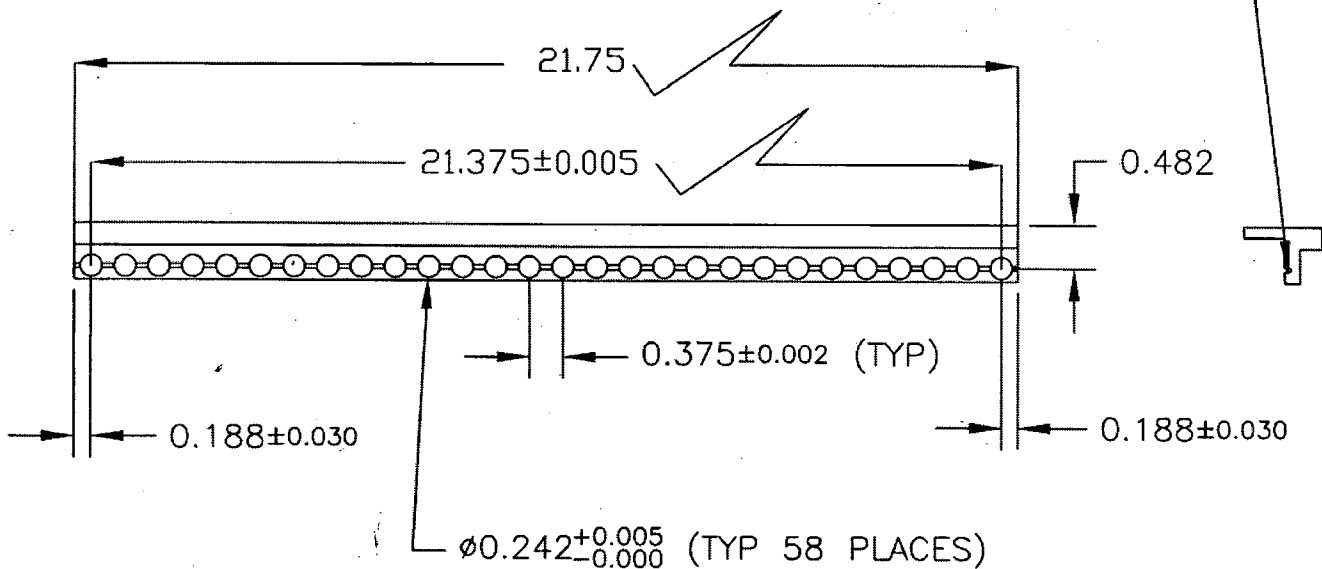
QA: N/C Closed: _____ Date: _____

DART**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA**RELEASED**

05.03.31

DESIGN	DRAWN BY	DRAWING NO.	REV. B
05.02.02	91.05.05	D1038	SHEET 1 OF 1
DATE	04.05.14	TITLE	SCALE
05.02.02	05.02.02	1/4 TURN FASTENER RAIL	NTS
CHECKED	APPROVED	NEW ISSUE	
A	B	UPDATE TOLERANCE	
B		REDRAWN, UPDATE NOTES	

STAKE Ø0.50 TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)

**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
37878

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TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**FACTURE
INVOICE****48897**

26-Jul-2006

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE: PO00001740****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
- 1	80	80	D1038-58B	\$2.25	\$180.00
SUB TOTAL:					\$180.00
TPS/GST:					\$10.80
TVQ/PST:					\$0.00
TOTAL AMOUNT DUE:					\$190.80

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE**CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

48897

26-Jul-2006

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

PURCHASE ORDER/

PO00001740

NO. DE COMMANDE:



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	80	80	D1038-58B	BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐